

Date: Monday, 10/11/2008 10:46:23 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DECK PLATE KIT
Job Number :	43280		
Estimate Number :	11233		
P.O. Number :		Part Number :	D350616015
This Issue :	10/11/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D350-616 REV D
First Issue :	//	Project Number :	N/A
Previous Run :	41359	Drawing Revision :	D
Written By :		Material :	
Checked & Approved By :	JUD 08.11.10	Due Date :	21/11/2008
Comment :	Est Rev:C Removed Manufacturing 05-12-05 JLM Est Rev:D Add D3494-1 05-12-05 JLM Est rev E added parts per NCR 08-041 08.04.30 EC verified by: DD		

Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



JUD 08.11.11



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D350-616-015 CHG002

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2344	Litter Deck Plate, 350
-----	-------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2344 Deck Plate (Aft) 38810

AS 08/11/11 (2)

4.0	D2348	Wearplate
-----	-------	-----------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2348 Wear Plate (Key Way) 39578

AS 08/11/11 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/11/2008 10:46:23 AM
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Drawing Name: DECK PLATE KIT

Job Number: 43280

Part Number: D350616015

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D2353 Stiffener



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2353 Stiffener 39639

SS 08/11/11 (x2)

6.0 D2364 Deck Plate, Fwd 350 Litt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2364 Deck Plate (Fwd) 4423

SS 08/11/11 (x2)

7.0 D2365 Wearplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2365 Wear Plate (Pip Pin) 41424

SS 08/11/11 (x2)

8.0 D23691 Deck Plate Locator Brackets



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2369-1 Locator Plate 811425

SS 08/11/11 (x2)

9.0 D23693 Deck Plate Locator Brackets



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2369-3 Locator Plate 39640

SS 08/11/11 (x2)

10.0 AN960JD10 Washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

10 AN960JD10 Washer M169659

SS 08/11/11 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: DECK PLATE KIT

Job Number: 43280

Part Number: D350616015

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

11.0	MS20426AD45	Rivet
------	-------------	-------



Comment: Qty.: 25.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

25 MS20426AD4-5 Rivet M3459

SS 08/11/11 (X2)

12.0	MS20426AD46	Rivet
------	-------------	-------



Comment: Qty.: 25.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

25 MS20426AD4-6 Rivet M105144

SS 08/11/11 (X2)

13.0	MS20426AD57	Rivet
------	-------------	-------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS20426AD5-7 Rivet M7681

SS 08/11/11 (X2)

14.0	MS20426AD58	Rivet
------	-------------	-------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS20426AD5-8 Rivet M4533

SS 08/11/11 (X2)

15.0	MS20601AD4W2	Rivet
------	--------------	-------



Comment: Qty.: 15.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

15 MS20601AD4W2 Blind Rivet M108246

SS 08/11/11 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 43280

Part Number: D350616015

Job Number:



Seq. #: Machine Or Operation: Description :

16.0 MS20601AD4W3 Rivet



Comment: Qty.: 30.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

30 MS20601AD4W3 Blind Rivet M107283

17.0 MS21042L3 Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L3 Nut (or -3) M109031

18.0 MS24693C48 Screw



Comment: Qty.: 22.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

22 MS24693-C48 Screw (or -48) M104215

19.0 MS24693C273 Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS24693-C273Screw (or -273) M107394x4 M108246x8

20.0 D34941 Stub Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

STUB COVER

Batch: 41956

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/11/2008 10:46:23 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE KIT

Job Number: 43280

Part Number: D350616015

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

MS35207264

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M107959

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-616-015

Location: _____

PPP Rev: _____

24.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

Job Completion



MF 08-11-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE 06.01.19		TITLE AS350/355 LITTER KIT INSTALLATION SCALE NTS	
A	95.02.20	NEW ISSUE	
B	96.01.09	ADD VIEW OF D2493 TO SHEET 9	
C	06.01.10	ADD DSI 9112/9117/9130/9236/9310	
D	06.01.19	ADD D3494-1 STUB COVER	

QTY - 011	Qty - 013	Qty - 015	Part Number	Description
X			D350-616-011	Full Litter Kit
1	X		D350-616-013	Deck Plate and Tie Down Kit
	1	X	D350-616-015	Deck Plate Kit
		1	D2344	DECK PLATE (AFT)
		4	D2348	WEAR PLATE (KEY WAY)
	1		D2350	LITTER TIE DOWN (NON-LOCKING)
		1	D2353	STIFFENER
	1		D2360	LITTER TIE DOWN (LOCKING)
		1	D2364	DECK PLATE (FWD)
		2	D2365	WEAR PLATE (PIP PIN)
		1	D2369-1	LOCATOR PLATE
		1	D2369-3	LOCATOR PLATE
1			D2370	LITTER ASSEMBLY
1			D2493	PATIENT STOP
		1	D3494-1	STUB COVER
		10	AN960JD10	WASHER
		25	MS20426AD4-5	RIVET
		25	MS20426AD4-6	RIVET
		6	MS20426AD5-7	RIVET
		6	MS20426AD5-8	RIVET
		15	MS20601AD4W2	BLIND RIVET (OR CR9162-4-2)
		30	MS20601AD4W3	BLIND RIVET (OR CR9162-4-3)
		22	MS24693-C48	SCREW (OR MS24693-48)
		6	MS24693-C273	SCREW (OR MS24693-273)
		6	MS21042L3	NUT (OR MS21042-3)
		4	MS35207-264	SCREW

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WORK ORDER
NO. 43280

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.01.19
CERT. NO.: SH96-10
ISSUE NO.: 2

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DATE 06.01.19		TITLE AS350/355 LITTER KIT INSTALLATION	SCALE NTS

GENERAL NOTES:

1. COMPATIBILITY

COMPATIBILITY OF THIS INSTALLATION WITH THE AIRCRAFT IS THE RESPONSIBILITY OF THE INSTALLER. ENSURE THAT THIS INSTALLATION DOES NOT CONFLICT WITH A PREVIOUS MODIFICATION.

2. WORKMANSHIP

UNLESS OTHERWISE STATED, ALL WORKMANSHIP SHOULD BE TO THE STANDARD SET BY THE AIRCRAFT MAINTENANCE MANUAL.

3. INSTALLATION INSTRUCTIONS

THIS DRAWING IS TO BE USED IN CONJUNCTION WITH INSTALLATION INSTRUCTIONS IIN-D350-616.

4. CONTINUING AIRWORTHINESS

THIS INSTALLATION SHOULD BE MAINTAINED IN ACCORDANCE WITH MAINTENANCE MANUAL SUPPLEMENT MMS-D350-616.

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-616-011	31.3 lb	17.3 in	541.5 in-lb	63.8 in	1996.9 in-lb
Full Litter Kit	14.19 kg	0.44 m	6.24 m-kg	1.62 m	22.99 m-kg
D350-616-013	6.3 lb	15.4 in	97.0 in-lb	52.0 in	327.6 in-lb
Deck Plate & Tie Down	2.86 kg	0.39 m	1.12 m-kg	1.32 m	3.78 m-kg
D350-616-015	2.8 lb	15.6 in	43.7 in-lb	53.0 in	148.4 in-lb
Deck Plate Kit	1.27 kg	0.40 m	0.51 m-kg	1.35 m	1.71 m-kg
Person Approximate CG	lb	18 in	in-lb	72 in	in-lb
	kg	0.46 m	m-kg	1.88 m	m-kg

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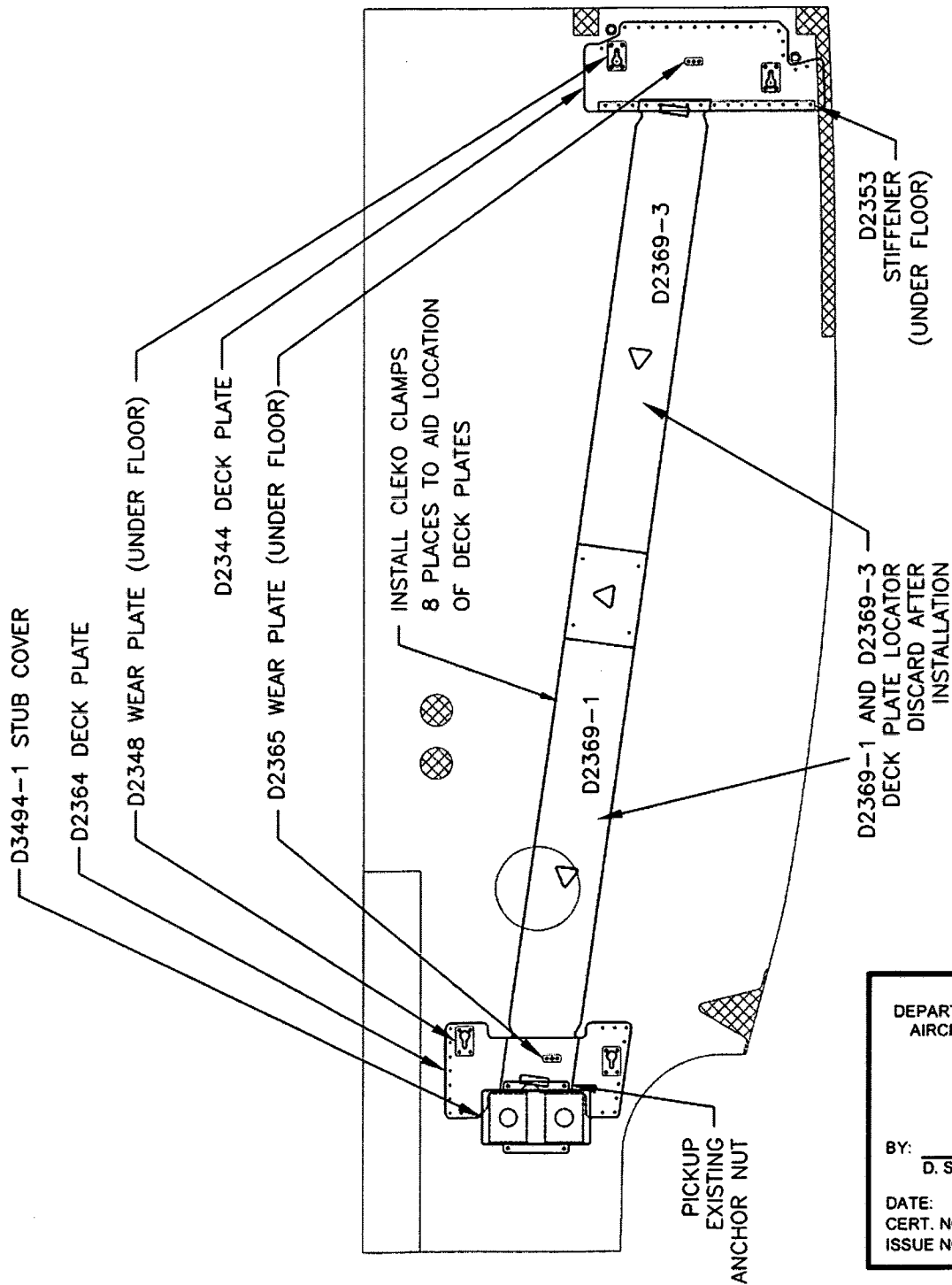
CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
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BY:	D. SHEPHERD (DE # 02)
DATE:	06.01.19
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DATE 06.01.19	TITLE AS350/355 LITTER INSTALLATION		SCALE NTS

**FIGURE 1**

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APPROVED

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DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE NTS

PICK UP ON EXISTING RIVETS
USE MS20601AD4W3 (CR9162-4-3)
OR MS20426AD4-6

MS24693C48
(10 PLACES)

INBOARD

FWD

EXISTING SCREW

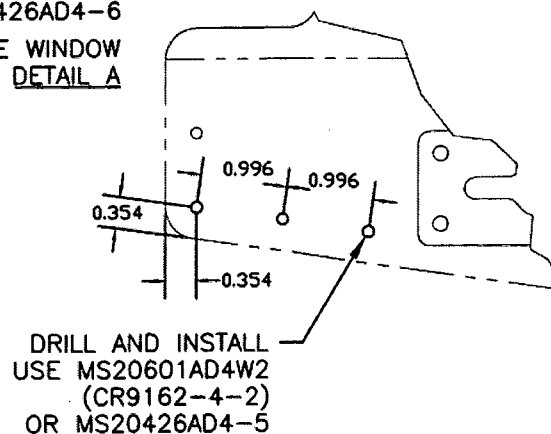
D2348 AND D2365
MS24693-C48
(UNDER FLOOR)

FOR HELICOPTERS WITH
LARGE NOSE WINDOWS
PICK UP ON EXISTING RIVETS
USE MS20601AD4W3
(CR9162-4-3)
OR MS20426AD4-6
FOR SMALL NOSE WINDOW
SEE DETAIL A

MS20601AD4W2 (CR9162-4-2)
OR MS20426AD4-5
(14 PLACES)

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FIGURE 2



DETAIL A

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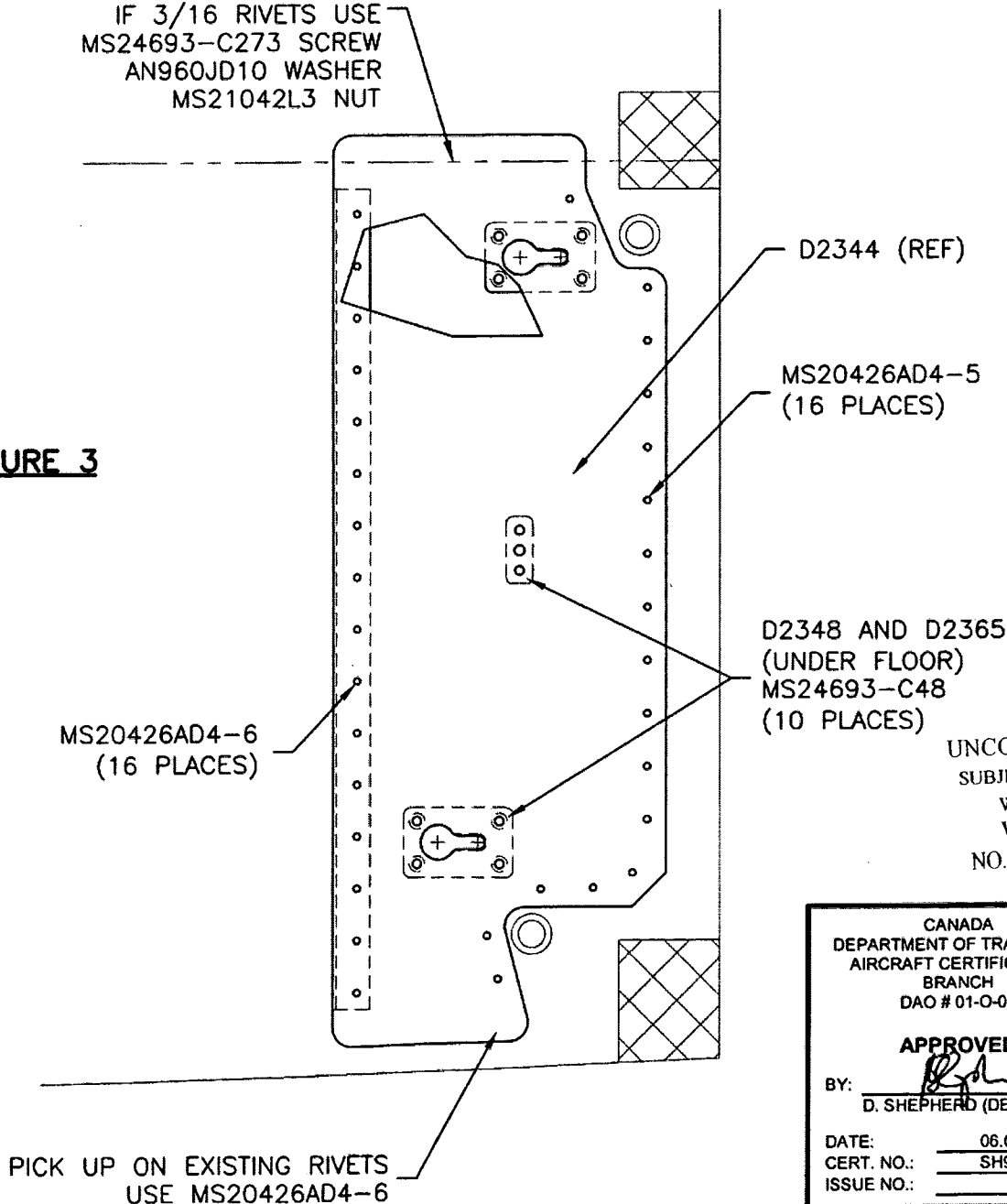
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DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE NTS

PICK UP ON EXISTING RIVETS
IF 5/16 RIVETS USE
MS20426AD5-7/MS20426AD5-8
IF 3/16 RIVETS USE
MS24693-C273 SCREW
AN960JD10 WASHER
MS21042L3 NUT

FIGURE 3

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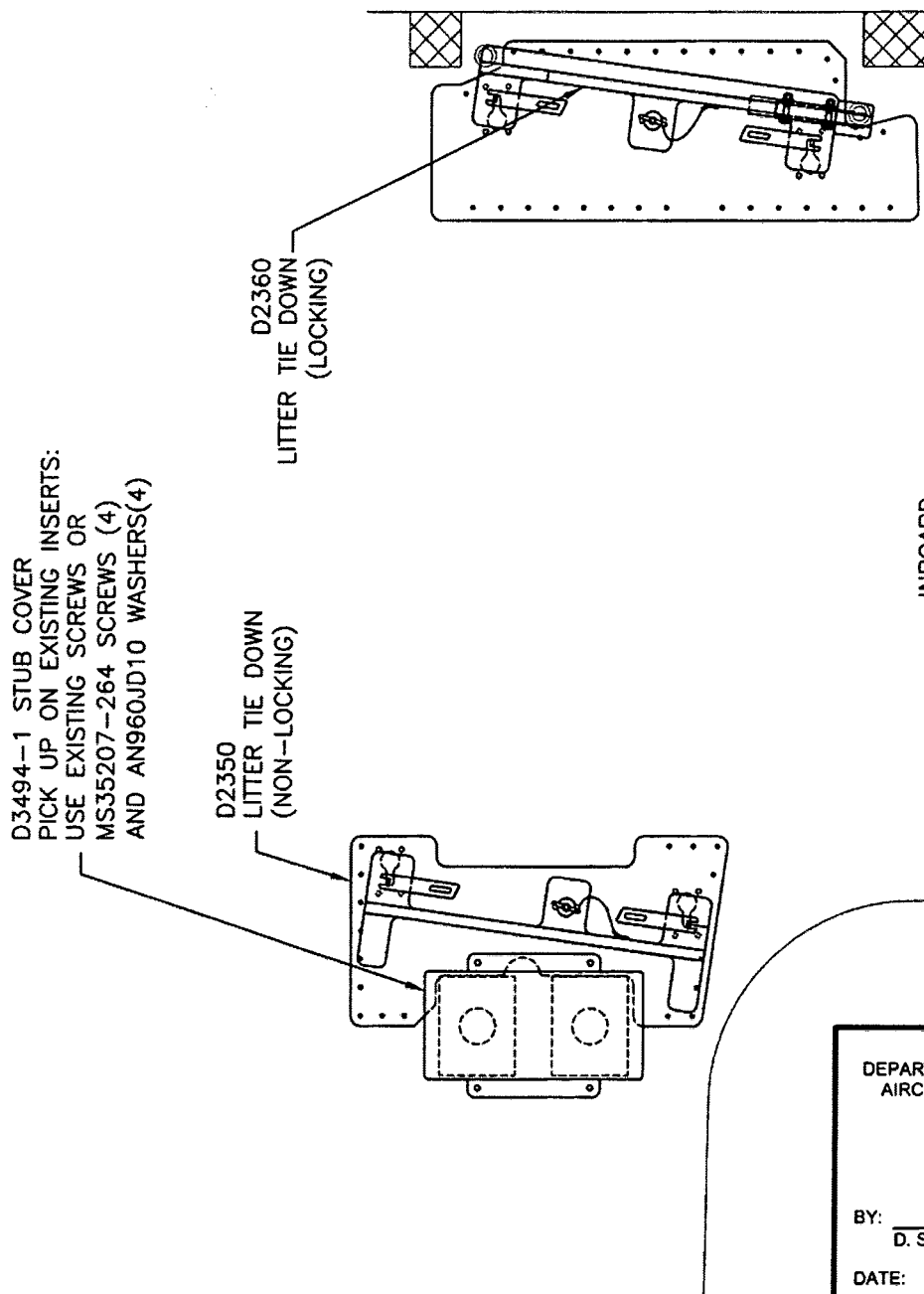
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FIGURE 4: LITTER TIE DOWN INSTALLATION



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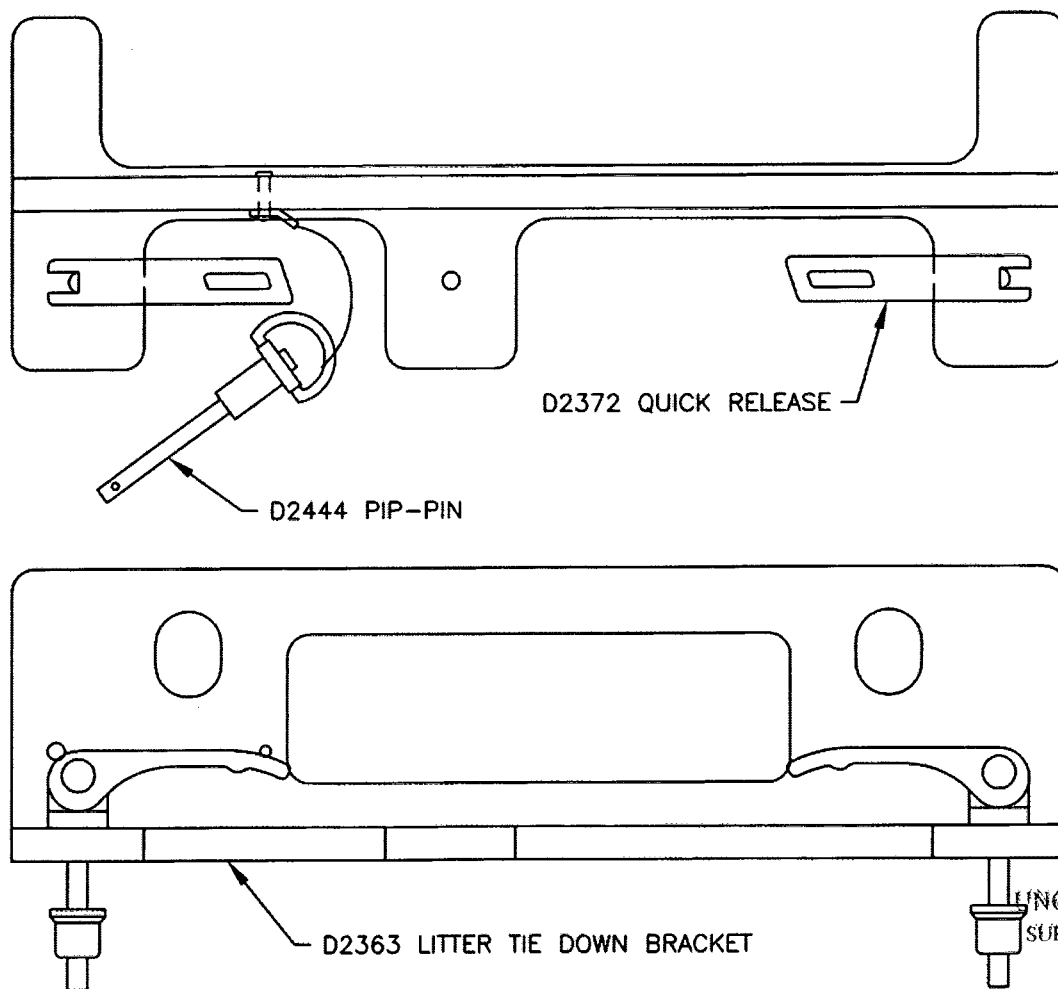
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FIGURE 5: D2350 LITTER TIE DOWN ASSEMBLY
(PART REFERENCE)

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DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE NTS

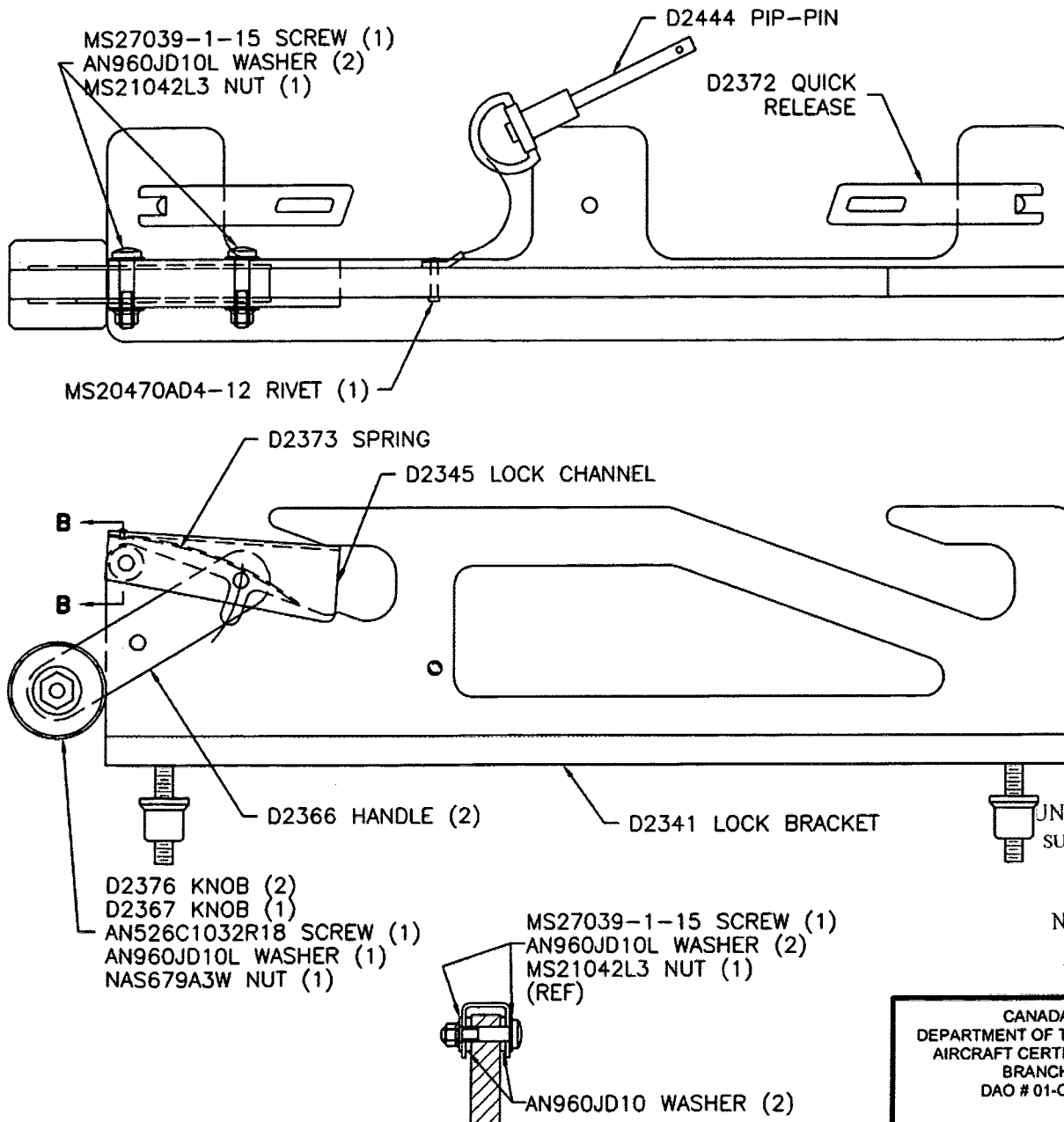
**SECTION B-B**

FIGURE 6: D2360 TIE DOWN ASSEMBLY
(PART REFERENCE)

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DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE NTS

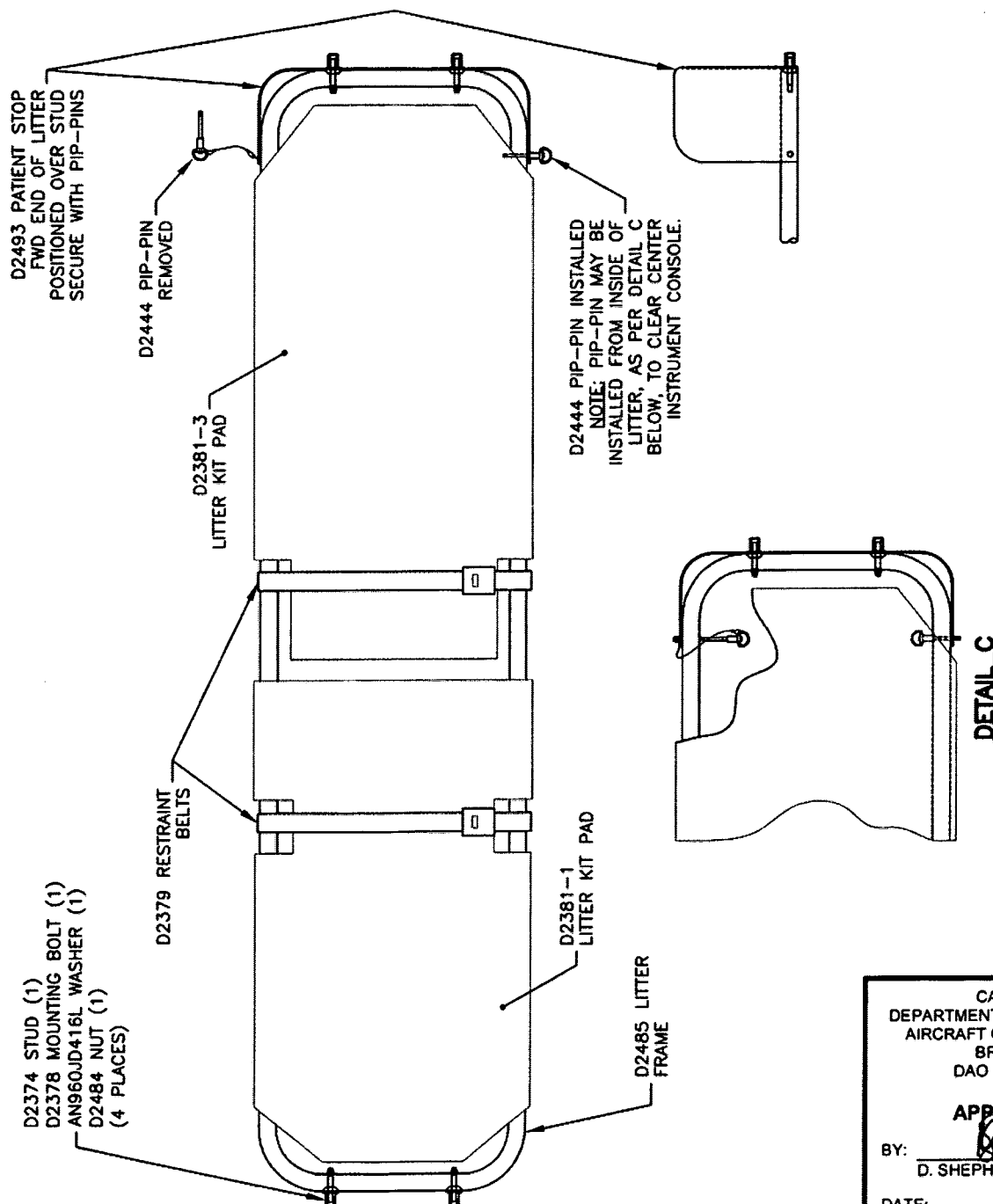


FIGURE 7: D2370 LITTER ASSEMBLY
(PART REFERENCE)

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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.01.19
CERT. NO.: SH96-10
ISSUE NO.: 2

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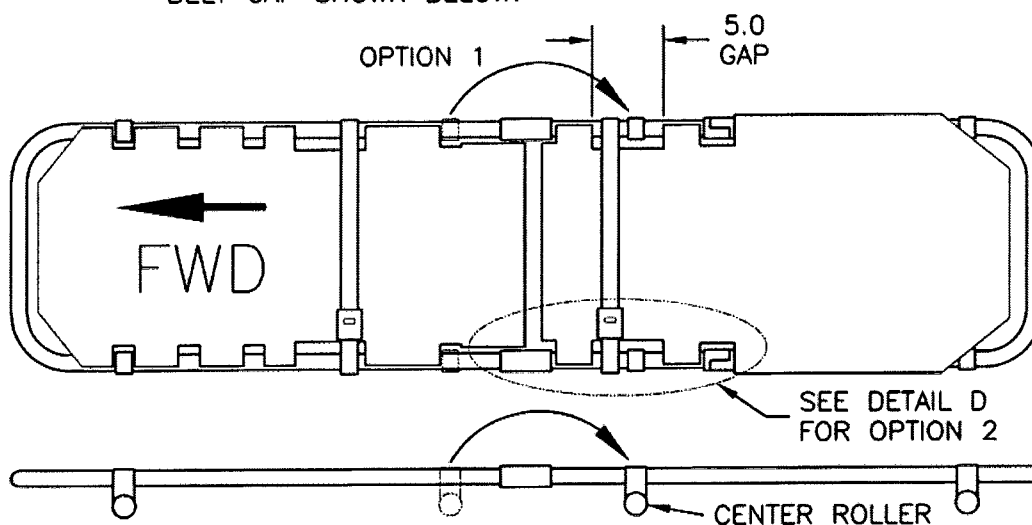
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D350-616	REV. D SHEET 10 OF 13
DATE 06.01.19	TITLE AS350/355 LITTER KIT INSTALLATION		SCALE NTS

COMPATIBILITY WITH ENERGY ATTENUATING SEATS

TO FACILITATE INSTALLATION OF THE D350-616-011 LITTER KIT WITH THE SEAT RAILS OF THE ENERGY ATTENUATING SEATS, IT IS ACCEPTABLE TO MOVE THE CENTER ROLLER SUPPORT AFT AS INDICATED:

OPTION 1. MOVE THE CENTER ROLLER ANYWHERE WITHIN THE 5.0" WIDE BELT GAP SHOWN BELOW.



OPTION 2. FOR COMPATIBILITY WITH EXTENDED SEAT RAILS, IT IS ALSO ACCEPTABLE TO CUT A 1.125" WIDE x 1.00" DEEP SLOT FOR INSTALLATION OF THE CENTER ROLLER JUST BEFORE THE HEADREST HINGE AS SHOWN BELOW. ENSURE THE SLOT IS CENTERED BETWEEN THE RIVETS AND LEAVES MAX. EDGE DISTANCE POSSIBLE.

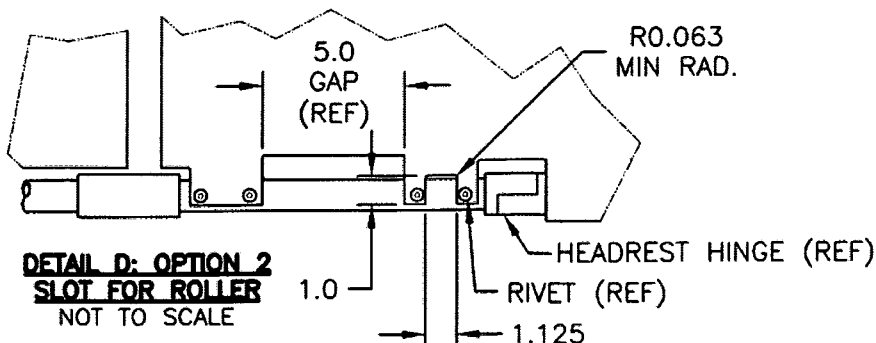


FIGURE 8: CENTER ROLLER RE-LOCATION

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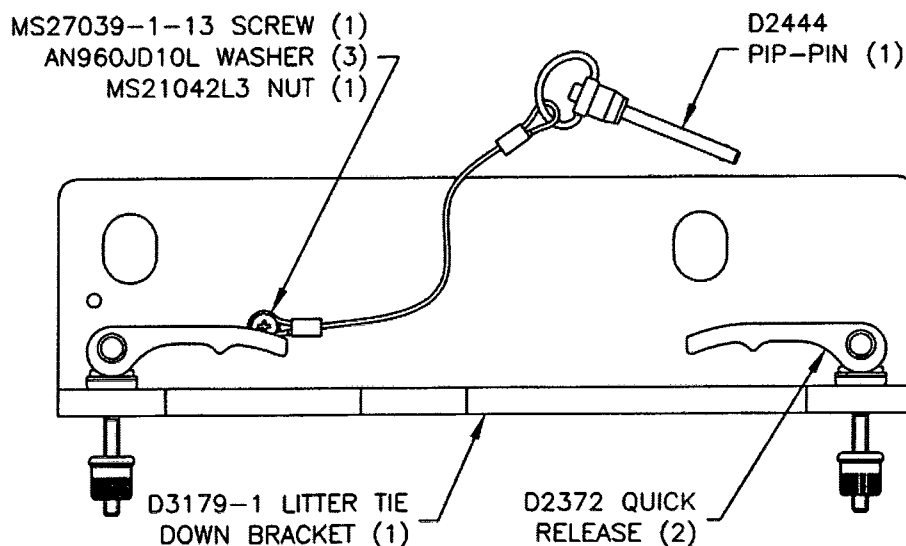
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DATE 06.01.19		TITLE AS350/355 LITTER KIT INSTALLATION	SCALE 1:2

COMPATIBILITY WITH GENEVA CONSOLE

FWD LITTER TIE DOWN BRACKET D3179-041 CAN BE USED IN LIEU OF D2350 LITTER TIE DOWN BRACKET REFERRED TO IN THE PARTS LIST FOR COMPATIBILITY WITH THE GENEVA CONSOLE. TO ASSEMBLE D3179-041, ORDER D3179-1 FROM DART AND TRANSFER HARDWARE FROM D2350 AS SHOWN BELOW. IT IS ACCEPTABLE TO TRIM D3179-1 AS REQUIRED FOR FIT AS LONG AS A MINIMUM EDGE DISTANCE OF 0.250" IS MAINTAINED FROM THE EDGE OF ALL HOLES AND SLOTS. PRIME AND PAINT IN ACCORDANCE WITH THE AIRCRAFT MAINTENANCE MANUAL PRIOR TO FINAL INSTALL.



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**FIGURE 9: D3179-041 FWD
LITTER TIE DOWN**

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COMPATIBILITY WITH SLIDING DOORS

AIRCRAFT EQUIPPED WITH A SLIDING DOOR CAN BE MODIFIED AS FOLLOWS TO BE COMPATIBLE WITH D350-616-011 LITTER KIT.

- (1) TRIM D2344 DECK PLATE TO WITHIN 0.05" OF THE DOOR RAIL AS SHOWN IN FIGURES 10 & 11. TOUCH UP WITH PRIME AND PAINT AS REQUIRED PER THE AIRCRAFT MAINTENANCE MANUAL.
- (2) DRILL FOUR 0.128" DIAMETER HOLES IN D2344 DECK PLATE AS SHOWN IN FIGURE 11. TOUCH UP WITH PRIME AND PAINT AS REQUIRED PER THE AIRCRAFT MAINTENANCE MANUAL.
ATTACH D2344 DECK PLATE PER IIN-D350-616 REV. A. IN THE FOUR DRILLED HOLES, FASTEN TO AIRCRAFT FLOOR SKIN WITH AN ADDITIONAL FOUR MS20426AD4-5 BLIND RIVETS.
- (3) TRIM FAIRING AS SHOWN IN FIGURE 11.

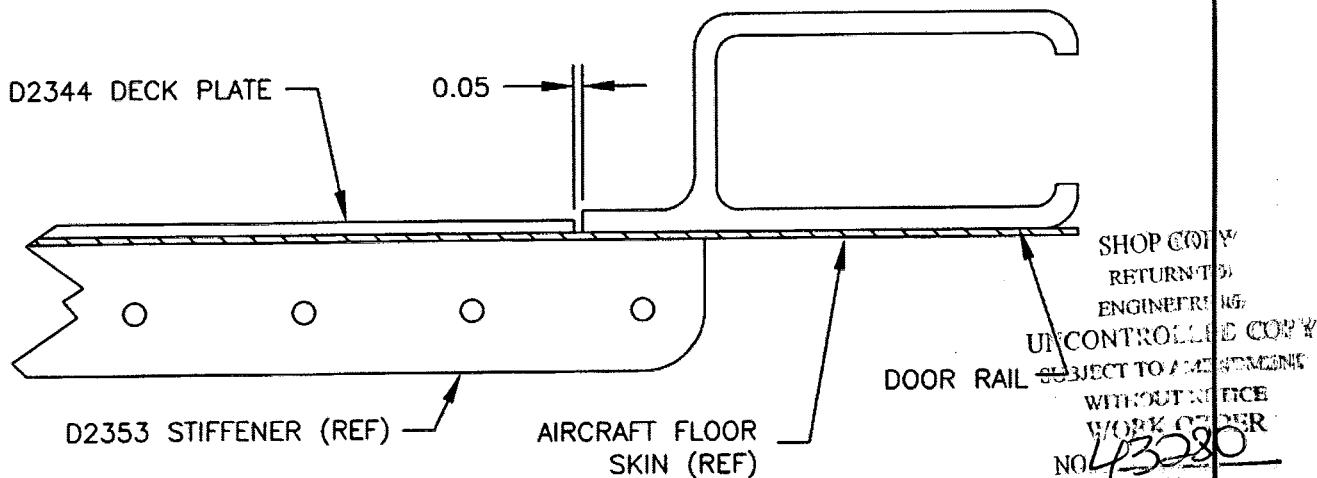


FIGURE 10
VIEW LOOKING AFT

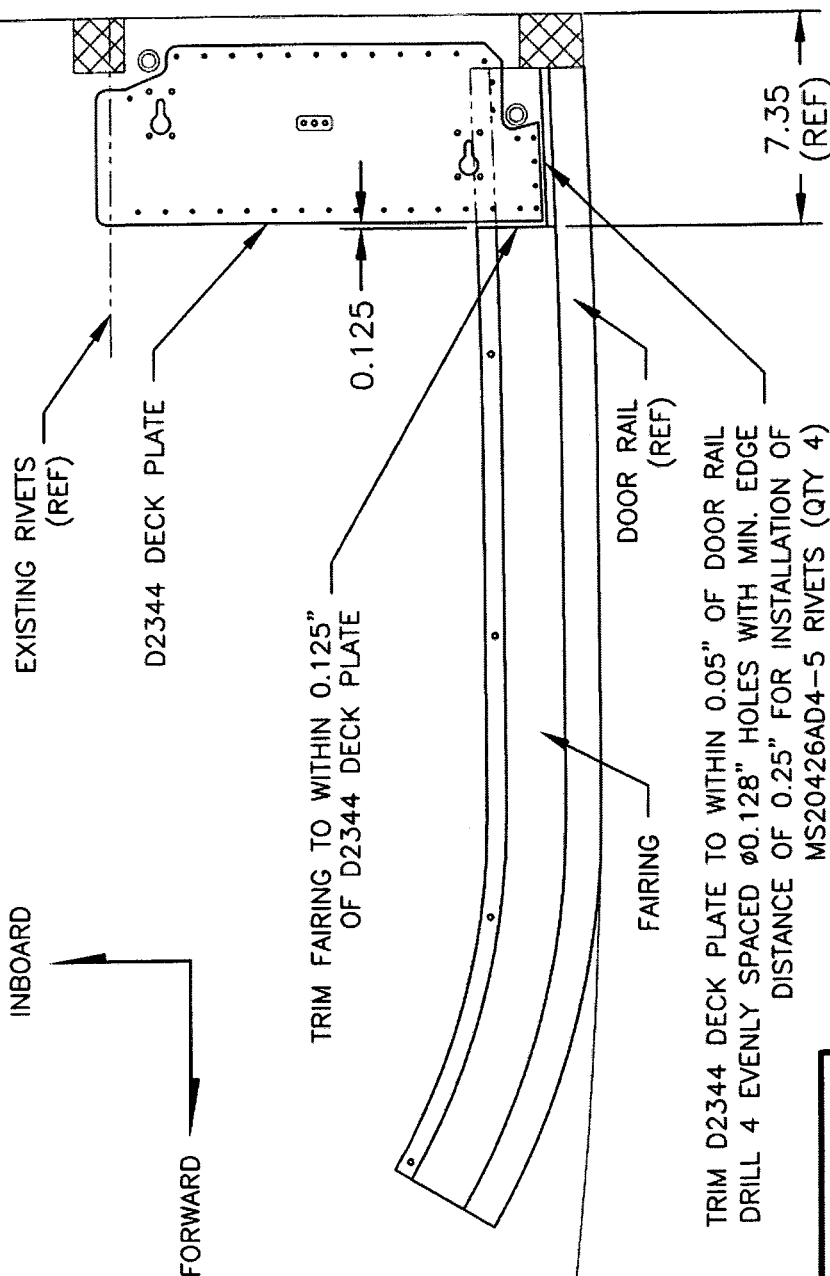
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COMPATIBILITY WITH SLIDING DOORS**FIGURE 11**

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